



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4855-1

Job Sheet 171743



Part No: D4855-1

Job Qty: 12 ea

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Machining-3		SBL 18/02/14
100	Bandsaw	12 pcs	2/15/18	2/15/18	0.00	0.34	Bandsaw1		SBL 18/02/14
110	CNC Vertical Machining	12 pcs	2/15/18	2/15/18	0.29	10.53	HAAS1-5		SBL 18/02/14
130	QC	12 pcs	2/15/18	2/15/18	0.00	0.00	QC8 Machining-3		J.A 18-02-14
140	HandFinish	12 pcs	2/15/18	2/15/18	0.00	0.48	HandFinish1		18-02-16 SA
150	QC	12 pcs	2/15/18	2/15/18	0.00	0.00	QC7-4		BR 18-2-20
160	Powdercoat	12 pcs	2/16/18	2/16/18	0.00	0.23	Powdercoat1		BR 18-2-20
170	QC	12 pcs	2/16/18	2/16/18	0.00	0.00	QC3		38
180	Packaging	12 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-2		5 FEB 21 2018
190	QC21-SA	12 Ea	2/16/18	2/16/18	0.00	0.00	QC21		

Part Op 100 - CUT BLANK AT 3.000"

Descriptions: 110 - 1-Machine per folio FB200

160 - START TIME: 8:00

Q.U.T: 3200 FINISH: 9:00

FEB 21 2018

DAS
21
9:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500	6061-T6 Aluminumbar 4.500" X 4.500"	3 ft (.25 ea)	90-Start up Operation	SC42381

5036064

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B4.500X4.500	3	5	0

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____			Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____			Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
			Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Composite ☐	Supplier ☐			

Date :	Step #:	QTV Effort:	MRB (QSI042) Approval
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Description Work Order Deviation

Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com



Container No: S042386



Part: D4855-1

Serial No/Batch: S042386

Revision: D4855

Inspector:

Date: 02/14/18 13:45 PM

Root Cause		 Container No:  Part: D4855 - 1 Serial No/Batch: SD Revision: D4855 Inspector: Date: 02/14/18 13:45 PM	
Environment	No Re-verification	Pressure/Forced	
Design	Operator	Bending	
Doc/Data	Offset/Setup	Centre Not Concentric	
Equip/Tooling	Supplier	Cracks	
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	
Material	Use for Testing	Cuffs	
Internal Transport	Poor Information	Crushing	
Tribal Knowledge	Rushing	Heat Treat	
LOA	Product Improvement	Wave/Twist in Tube	
Substation	Process Improvement	Marks/Chatter	
Past Expiry Date	Manufacturing Process	Inspection Incomplete/Unqualified	
Misidentified	Past Due	Contamination	
		Countersink	
		Cut Too Short	
		Instructions Incomplete/Unclear	
		Drill Holes	
		Wrong Stock Pulled	
		Out of Sequence	
		Off-set	
		Mislabeled	
		Fit/Function	
		Misaligned/off center	
		Part Lost/Missing	
		Part Moved	
		Drawing	
		Finish	
		Misread	
		Turning Sequence	
		OTHER :	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches ± 0.010	0.885 0.865		, 875
2	Antenna Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	, 200
3	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940		, 970
4	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940		, 970
5	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850		, 1876
6	Antenna Bracket	3.750Inches ± 0.030	3.780 3.720		, 3752
7	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	, 250
8	Antenna Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	, 259
9	Antenna Bracket	2.130Inches ± 0.030	2.160 2.100		, 2125
10	Antenna Bracket	1.400Inches ± 0.030	1.430 1.370		, 1400
11	Antenna Bracket	1.260Inches ± 0.030	1.290 1.230		, 1260
12	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850		, 1880 1876
13	Antenna Bracket	0.280Inches + 0.006 - 0.001	0.286 0.279	Diameter	, 280
14	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	, 380
15	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	, 380
16	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	, 250
17	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240		, 251
18	Antenna Bracket	2.500Inches ± 0.030	2.530 2.470		, 250 2,500
19	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240		, 255
20	Antenna Bracket	4.250Inches ± 0.030	4.280 4.220		, 4252
21	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	, 250

Plex 2/8/18 7:18 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								